

# Work Order ID 55029

January 5, 2010 1:20:56 PM



Page 1

Item ID: D2665-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

*[Signature]*

Date: 10-1-05 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2665

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Program batch number 112- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet 113- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet 114- Machine Step # 3 of Folio and visually inspect as per attached

*MMF 2 2*  
*10/01/20*

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

*MMF 2 2*  
*10/01/20*

120

0.00



QC2- Inspect parts off machine FAJ/FAIB

QC

Memo

0.00

Quality Control

*MMF 2 2*  
*10/01/21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2665-2 PAR #: \_\_\_\_\_ Fault Category: Machined Parts NCR: Yes No DQA: [Signature] Date: 10-02-10  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 10/02/11

NCR: <u>55029</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/20	100	First part → dim B is .089" ANOTHER PART IS 0.088" Dimension build up → R.C. TOLERANCE BUILDUP	GP 10.01.20 per QSI 042	SCRAP. Affects strength and fatigue in critical section. destroy no replace Qty x 2.	DJP 10/01/20	8F 10/01/23	GP 10.01.20 per QSI 042	S 10/01/20

NOTE: Date & initial all entries

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January 5, 2010 1:20:56 PM



Page 2

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Setup Start



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Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 10/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



SP 10/01/23

2 2

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



u 10/01/25

(X2) 9

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



M 113170

=> u 10/01/26

(X2) 8

Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:00 AM OVEN TEMPERATURE:  
7:30 AM FINISH TIME 320°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 55029**

January 5, 2010 1:20:56 PM

Page 3

Item ID: D2665-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 05/1/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 10-01-26 (2) ✓

170

Identify as per dwg &amp; Stock Location: 436

0.00



Packaging

Memo

0.00

Packaging

10-1-27 (2) ✓

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/27 MF 10-1-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 5, 2010 1:21:00 PM

Page 1

Work Order ID: 55029



Parent Item: D2665-2



Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	11.0000	6.0000			

Saddle Billet, 7075

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

11

46410

11

4 DTP 10/01/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	55029
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b>	D2665-2
<b>Inspection Dwg:</b> D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.115	0.1155	0.115	0.113		
B	0.100	0.140		0.089	0.100	0.111	0.121		
C	1.125	1.145		1.1375	1.129	1.128	1.129		
D	0.615	0.685		0.665	0.680	0.680	0.680		
E	0.240	0.260		0.246	0.236	0.258	0.258		
F	1.313	1.343		1.323	1.323	1.323	1.323		
G	0.210	0.230		0.229	0.2205	0.220	0.220		
H	0.100	0.180		0.135	0.135	0.130	0.128		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.577	1.5675	1.566	1.567		
K	0.235	0.240		0.2375	0.237	0.237	0.237		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		0.995	0.997	0.997	0.995		
N	0.510	0.515		0.511	0.512	0.511	0.512		
O	5.990	6.010		6.001	6.003	6.001	6.006		
P	1.245	1.255		1.250	1.247	1.249	1.250		
Q	2.495	2.505		2.500	2.497	2.499	2.499		
R	0.313	0.318		0.314	0.315	0.315	0.315		
S	0.315	0.322		0.316	0.316	0.316	0.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.7945	0.796	0.793	0.794		
W	0.540	0.560		0.548	0.549	0.550	0.549		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.259	0.259	0.259	0.259		
Z	0.912	0.932		0.9245	0.921	0.920	0.920		
AA	0.490	0.510		0.496	0.499	0.499	0.500		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: *DSI* / *MND*  
Date: 10/01/12 / 10/01/21

Audited by: *RF*  
Date: 10/01/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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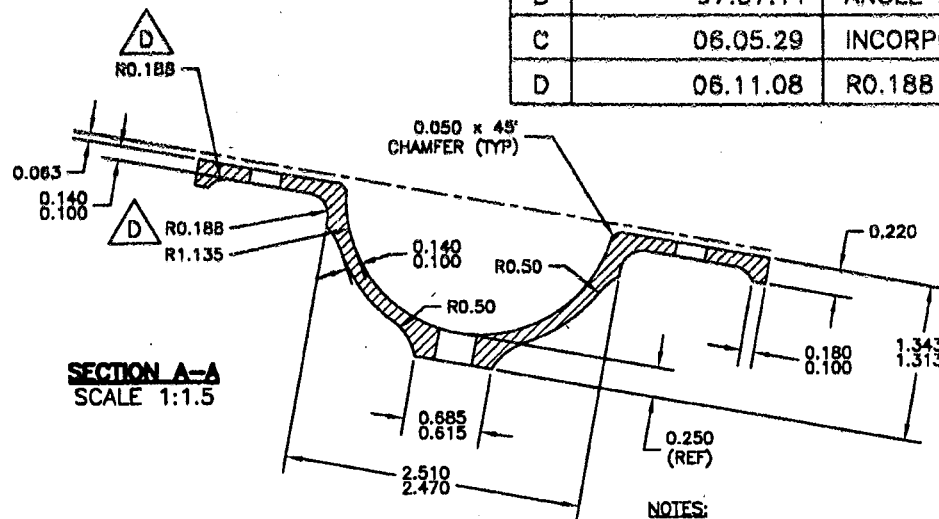
**DART**

WORK ORDER

NO. 55029

10-1-05

DESIGN	CH	DRAWN BY	CB	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	PH	APPROVED	CH	DRAWING NO. D2665
				REV. D SHEET 1 OF 1
DATE	06.11.08	TITLE	SADDLE FWD OUTSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE		
B	97.07.11	ANGLE AND NOTES ADDED		
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095		
D	06.11.08	RO.188 WAS RO.30; Ø0.316 WAS Ø0.313		

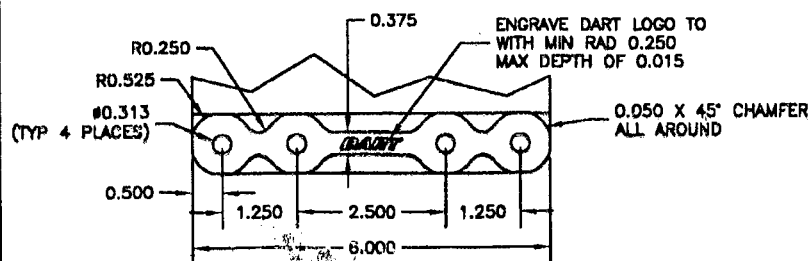
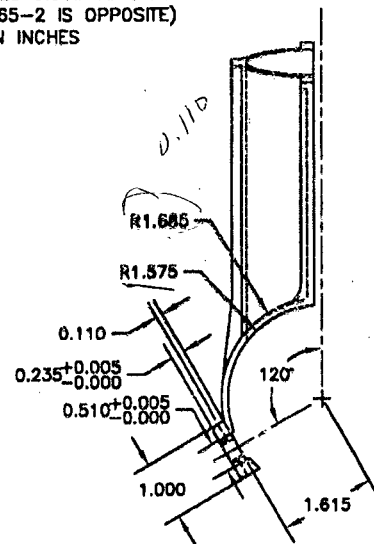
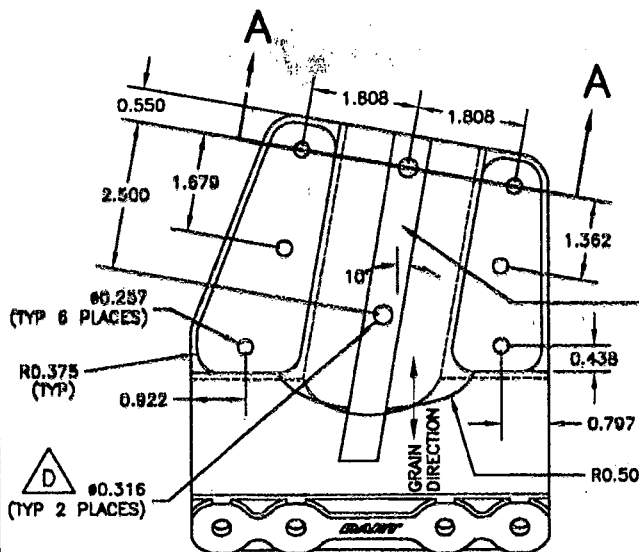


RELEASED

07.02.12

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QG-A-250/12)  
(MAKE FROM D8101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



D2665-1 SADDLE FWD OUTSIDE HIGH

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries